

21

DART AEROSPACE LTD		Work Order:	19167
Description: Spacepod Hardware Kit		Part Number:	K10018
-1			
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C		Qty:	2 Kits
RF 03.04.30			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: K10018 Kit to be made in multiples of 7. (1) K10018 requires (2) D2174-041. (1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle	14	03.05.12	2
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2174-1 Batch:			
3	MV	Cut (2) blanks per (1) K10018 Kit Cut blanks: (12.200" x 2.960") grain along 2.960 Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2175 Batch:			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 Identify as D2174-1			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 Identify as D2175	D 2174-041 stack B 030512		
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 23 MS20470AD4-6 Rivet _____ Identify as D2174-041			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

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21	KP	Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2174-041</td> <td>Web Assembly</td> <td>010562</td> </tr> <tr> <td>1</td> <td>D2985</td> <td>Decal</td> <td>B12773</td> </tr> <tr> <td>8</td> <td>A3235-020-935</td> <td>Washer</td> <td></td> </tr> <tr> <td>16</td> <td>AKS7-1032-130</td> <td>Insert-ALS4-1032-130</td> <td>M11912</td> </tr> <tr> <td>8</td> <td>AN3-3A</td> <td>Bolt</td> <td>M13155</td> </tr> <tr> <td>8</td> <td>AN3H4A</td> <td>Bolt (or AN3H4)</td> <td>M12493</td> </tr> <tr> <td>36</td> <td>AN525-10R7</td> <td>Screw</td> <td>M11822</td> </tr> <tr> <td>8</td> <td>AN960JD10</td> <td>Washer</td> <td>M10140</td> </tr> <tr> <td>16</td> <td>AN960JD10L</td> <td>Washer</td> <td>M12749</td> </tr> <tr> <td>16</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M12241</td> </tr> <tr> <td>8</td> <td>MS24694S67</td> <td>Screw-M9404</td> <td>M3108</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2174-041	Web Assembly	010562	1	D2985	Decal	B12773	8	A3235-020-935	Washer		16	AKS7-1032-130	Insert-ALS4-1032-130	M11912	8	AN3-3A	Bolt	M13155	8	AN3H4A	Bolt (or AN3H4)	M12493	36	AN525-10R7	Screw	M11822	8	AN960JD10	Washer	M10140	16	AN960JD10L	Washer	M12749	16	MS21042L3	Nut (or -3)	M12241	8	MS24694S67	Screw-M9404	M3108			
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22	QC4	Inspect Kit 100% for Completeness on the W/O	u	03.05.30	2																																																
23	ST	Identify and Stock	(P)	03.05.30	2																																																
24	AC	Cost / part 67.05	5ut	03.05.30	2																																																
25	DC	Close W/O 67.05 Inspect Level 21	(A)	03.05.30	-																																																

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	#

RELEASED
03.04.30 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

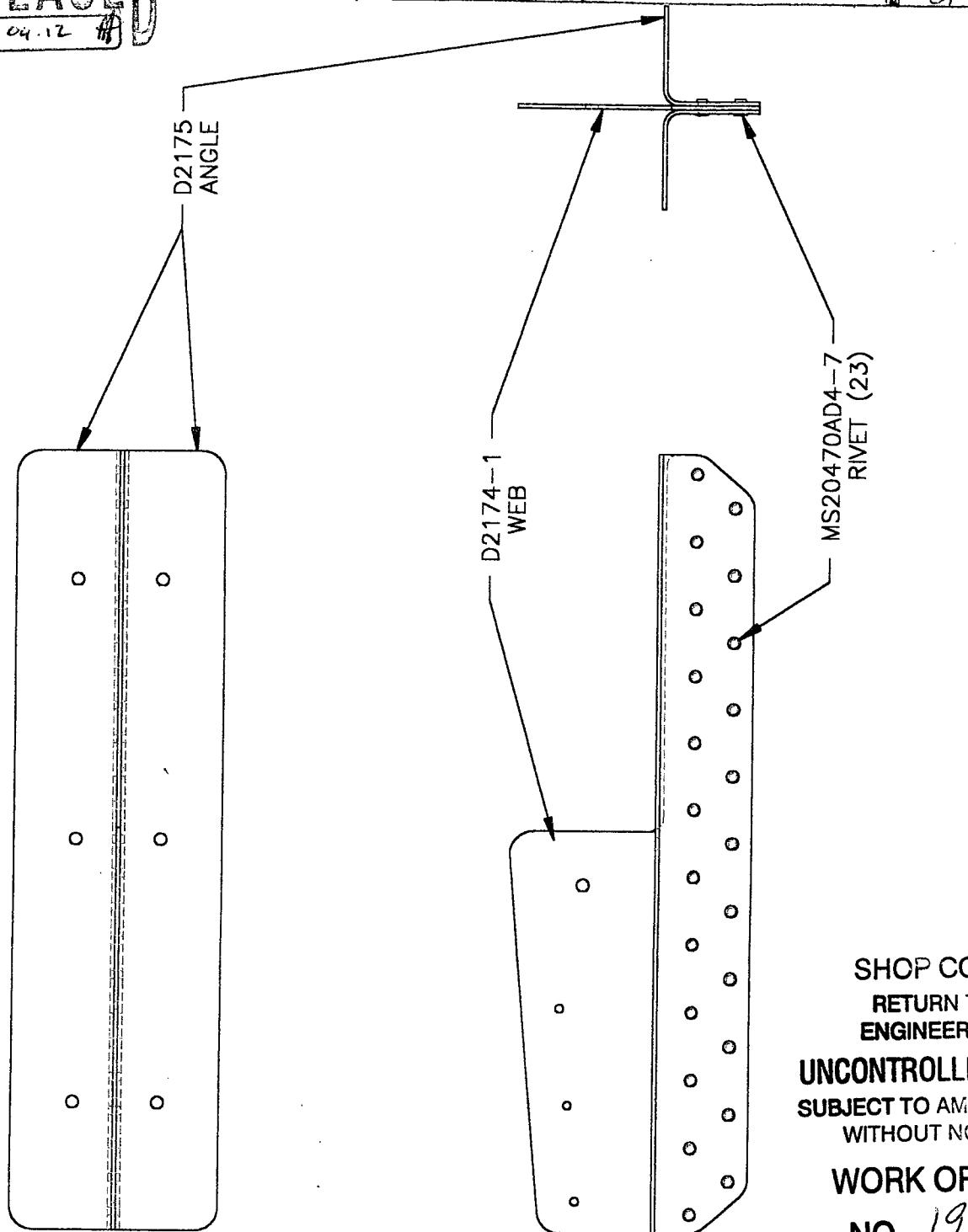
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN B. WILLIAMS	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bru</i>	APPROVED <i>RF</i>	DRAWING NO. D2174-041	REV. <i>RF</i> 00.07.06 SHEET 1 OF 1
DATE 95:10:25	TITLE WEB ASSEMBLY		
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC. OF CP	

RELEASED
00.04.12 *RF*



MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK
FINISH: ANODIZE-CLEAR Powder Coat White PER DART QST 005 43.5.1

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WITHOUT NOTICE

WORK ORDER
NO. 19167

Job Costing Report

Dart Aerospace Ltd.
HawkesburyMay 12, 2003
09:26 pm

Work Order No : 0019167
 Project Name : K10018
 Project For : WK321
 Work Order Type : Main
 Main WO Number :
 House Part Number : K10018
 Description : Spacepod Hardware Kit
 Manufactured : Yes
 Amount Req'd : *12 u*
 Amount Done : 0
 Start Date : 05-12-03
 Est Finish Date : 05-22-03
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00